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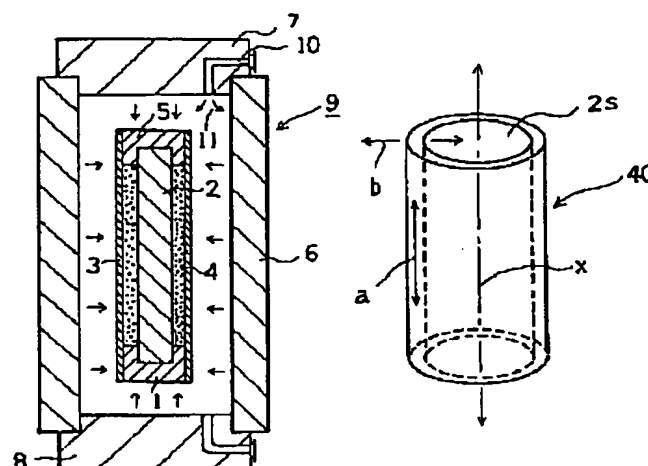
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TITLE : CYLINDRICAL FLUORORESIN
MOLDED PIECE AND PRODUCTION
THEREOF



ABSTRACT : PURPOSE: To form a molded piece having an MD/CD ratio ≤ 1.0 between a linear expansion coefficient MD in parallel to an axis of a cylinder and a coefficient CD vertical to the axis and a dispersion of ± 0.005 or less in apparent specific gravity by a method wherein fluororesin powder is charged between a mold and a cylindrical rubber mold, which are coaxially disposed, the powder is vertically pressurized to be preformed into a cylinder, and the molded piece.

CONSTITUTION: A round bar-form mold 2 and a cylindrical rubber mold 3 are coaxially fitted into a lower mold 1. A space between the molds 2, 3 is filled with fluororesin powder 4, thereafter being sealed by fitting an upper mold 5. These are put in a pressurizing device 9 to be pressurized by a pressurizing medium 11 injected through a drain 10. Thus, the powder 4 is axially and vertically pressurized to be preformed into a cylinder. The preform is removed, heated, and calcined to form a cylindrical fluororesin molded piece. In this method, the fluororesin molded piece has an MD/CD ratio ≤ 1.0 between a linear expansion coefficient MD in a direction (a) in parallel to a cylinder's axis X and a linear expansion coefficient CD in a direction (b) vertical to the axis and a dispersion of ± 0.005 or less in apparent density on the both ends in the direction (a), thus being improved in wearability.

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